

SPECIFICATION

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CERAMIC HONEYCOMB FILTER, ITS PRODUCTION METHOD, AND
PLUGGING MATERIAL FOR CERAMIC HONEYCOMB FILTER

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FIELD OF THE INVENTION

[0001] The present invention relates to a ceramic honeycomb filter for removing particulate matter from an exhaust gas discharged from diesel engines, its production method, and a plugging material for producing such
10 ceramic honeycomb filter.

BACKGROUND OF THE INVENTION

[0002] To remove particulate matter from an exhaust gas from diesel engines, a particulate-matter-capturing ceramic honeycomb filter comprising a
15 sintered ceramic honeycomb body with porous partition walls, through which the exhaust gas containing particulate matter passes, namely, a diesel particulate filter (DPF) has been developed and put into practical use. The ceramic honeycomb filter comprises a sintered ceramic honeycomb body having porous partition walls defining flow paths and a peripheral wall, and
20 plugs alternately sealing both ends of the flow paths. Because the ceramic honeycomb filter is exposed to high temperatures, the sintered ceramic honeycomb body is made of heat-resistant cordierite ceramics having small thermal expansion coefficients, and plugging materials are the same cordierite ceramics as those of the honeycomb bodies such that there are small
25 differences in thermal expansion between the plugs and the sintered ceramic honeycomb bodies.

[0003] When the exhaust gas containing particulate matter flows into such ceramic honeycomb filter, particulate matter in the exhaust gas are captured by fine pores in the porous partition walls. When the captured particulate matter

is excessively accumulated in the ceramic honeycomb filter, there is likely to arise increased pressure loss in the filter, resulting in decrease in the engine power. Accordingly, the ceramic honeycomb filter is periodically regenerated by burning the captured particulate matter by an external ignition means such as an electric heater, a burner, etc. A pair of ceramic honeycomb filters are usually mounted onto an automobile, utilizing an alternate regeneration method, in which while one filter is regenerated, the other filter is used.

[0004] With respect to characteristics, the ceramic honeycomb filter is required not only to suffer low pressure loss to avoid the decrease of engine performance, but also to have enough thermal shock resistance to withstand thermal shock due to rapid temperature changes at regeneration, the stop of an engine, etc. Accordingly, various improvements have been proposed on plugs for the ceramic honeycomb filters.

[0005] JP63-28875B discloses a method for plugging open ends of a sintered ceramic honeycomb body, comprising plugging a sintered honeycomb structure by a cordierite-forming material batch, and then sintering it at a temperature of 1300°C or higher to convert the cordierite-forming material batch to cordierite. This method provides a cordierite honeycomb filter having excellent thermal shock resistance and reliability, in which the predetermined open ends of the flow paths of the sintered ceramic honeycomb body are completely sealed.

[0006] JP2002-136817A discloses a ceramic honeycomb filter comprising sealing the predetermined open ends of flow paths of a sintered or unsintered ceramic honeycomb body with a plugging material comprising sintered powder and unsintered powder having the same composition as that of the sintered ceramic honeycomb body, and heating it at as high temperatures as 1400°C to form plugs. Because the plugging material contains pulverized

powder having the same composition as that of the sintered ceramic honeycomb body in this ceramic honeycomb filter, no cracking due to a thermal expansion difference occurs in the plugs or portions of the honeycomb structure near the plugs even at high temperatures, and there are no troubles such as the peeling of the plugs, etc.

[0007] It has been found, however, that when the plugging material is heated to a cordierite-forming temperature (for instance, 1300°C) or higher to bond it to the sintered ceramic honeycomb body as in the above conventional technologies, it is difficult to make the thermal expansion coefficient of the cordierite ceramic honeycomb structure equal to that of the plugs. Namely, because plate-like kaolin particles in a cordierite material for the sintered ceramic honeycomb body are oriented when passing through a narrow slit of an extrusion die in the extrusion-molding of the material, cordierite crystals formed by sintering are also oriented, so that the resultant honeycomb structure has a small thermal expansion coefficient in a flow path direction and a radial direction. However, because the plugging material does not pass through the narrow slit of the extrusion die, cordierite crystals are randomly oriented, resulting in a relatively large thermal expansion coefficient. Accordingly, there is a large difference in a thermal expansion coefficient between the honeycomb structure and the plugs.

[0008] In addition, large residual stress is generated in interfaces between the plugs and the sintered ceramic honeycomb body at a bonding temperature of 1300°C or higher. Large residual stress is likely to cause cracking in the plugs or in interfaces between the plugs and the honeycomb structure, and the peeling of the plugs, due to thermal shock by an exhaust gas and mechanical shock by engine vibration and vibration by contact with roads when mounted to automobiles.

[0009] JP63-24731B discloses a method for sealing predetermined flow

paths of a porous ceramic honeycomb structure by forming openings in a film attached to the ends of the porous ceramic honeycomb structure at predetermined points, and charging a plugging material into the flow paths through the openings. In Example 3 of this reference, a slurry containing alumina cement and pulverized mullite is introduced into predetermined flow paths of a ceramic honeycomb structure under vibration, and the resultant plugs are cured at a temperature of 55°C and a humidity of 90% for 2 hours, to integrate the plugs to the honeycomb structure. In this method, because the plug-bonding temperature is as low as 55°C, there is small residual stress in interfaces between the plugs and the ceramic honeycomb structure.

[0010] It has been found, however, that because the cordierite honeycomb structure has a small thermal expansion coefficient while the plugs composed of mullite and alumina cement have a relatively large thermal expansion coefficient, it is likely that cracking occurs between the ceramic honeycomb structure and the plugs by thermal shock by an exhaust gas, and that the plugs peel off, when mounted to an automobile.

OBJECTS OF THE INVENTION

[0011] Accordingly, an object of the present invention is to provide a ceramic honeycomb filter with small difference in a thermal expansion coefficient between the partition walls of a sintered ceramic honeycomb body and plugs, and with small residual stress because of a low plug-bonding temperature, thereby having excellent thermal shock resistance.

[0012] Another object of the present invention is to provide a method for producing such a ceramic honeycomb filter.

[0013] A further object of the present invention is to provide a plugging material for producing such a ceramic honeycomb filter.

DISCLOSURE OF THE INVENTION

[0014] The inventors have found that by forming a sintered ceramic honeycomb body by a material comprising cordierite as a main component, and by forming plugs by a plugging material containing ceramic particles and colloidal oxide, the colloidal oxide is converted to an amorphous oxide matrix even by low-temperature heating, thereby providing a ceramic honeycomb filter with small difference in a thermal expansion coefficient between the sintered ceramic honeycomb body and the plugs, and with small residual stress because of the low-temperature bonding of the plugs. The present invention has been completed based on this finding.

[0015] Thus, the ceramic honeycomb filter of the present invention comprises a sintered ceramic honeycomb body having porous partition walls defining flow paths, and plugs formed in predetermined flow paths to remove particulate matter from an exhaust gas passing through the porous partition walls, the sintered ceramic honeycomb body being made of a cordierite-based ceramic material; and at least part of the plugs comprising ceramic particles and an amorphous oxide matrix formed from colloidal oxide.

[0016] The ceramic particles are preferably cordierite particles and/or amorphous silica particles. The ceramic particles are preferably pulverized powder of the same material as the sintered ceramic honeycomb body. The colloidal oxide is preferably colloidal silica and/or colloidal alumina.

[0017] The method of the present invention for producing the above ceramic honeycomb filter comprises the steps of forming the sintered ceramic honeycomb body by a cordierite-based ceramic material, and heating a plugging material filled in predetermined flow paths of the sintered ceramic honeycomb body to a temperature of 1000°C or lower to form plugs bonded to the sintered ceramic honeycomb body.

[0018] The bonding temperature of the plugging material is preferably

500°C or lower, more preferably 150°C or lower.

[0019] At least part of the plugs are preferably formed by a plugging material containing ceramic particles and colloidal oxide.

[0020] The plugging material for the ceramic honeycomb filter of the present invention comprises ceramic particles and colloidal oxide.

BRIEF DESCRIPTION OF THE DRAWINGS

[0021] Fig 1 is a perspective view showing the appearance of the ceramic honeycomb filter of the present invention.

[0022] Fig. 2 is a schematic cross-sectional view showing the structure of the ceramic honeycomb filter of the present invention.

[0023] Fig. 3(a) is a schematic cross-sectional view showing the method of forming plugs in predetermined flow paths of the ceramic honeycomb filter.

[0024] Fig. 3(b) is a schematic cross-sectional view showing the method of forming plugs in predetermined flow paths of the ceramic honeycomb filter.

DESCRIPTION OF THE PREFERRED EMBODIMENTS

[0025] The ceramic honeycomb filter of the present invention comprises a sintered ceramic honeycomb body made of a cordierite-based ceramic material, and plugs formed in predetermined flow paths of the sintered ceramic honeycomb body, at least part of the plugs being formed by a plugging material comprising ceramic particles and colloidal oxide. By filling the plugging material into the predetermined flow paths of the sintered ceramic honeycomb body and then heating it, the colloidal oxide is converted to an amorphous oxide matrix, resulting in strong bonding of the plugs to the sintered ceramic honeycomb body. The plugging material for plugs will be explained first, and the ceramic honeycomb filter and its production method will then be explained.

[0026] [1] plugging material

[0027] Ceramic particles in the plugging material for the ceramic honeycomb filter of the present invention are preferably cordierite particles and/or amorphous silica particles. This is because small thermal expansion coefficients of cordierite particles and amorphous silica particles provide the plugs with a small thermal expansion coefficient, so that there is a small difference in a thermal expansion coefficient between the plugs and the sintered cordierite ceramic honeycomb body. There is only small residual stress in the plugs containing such ceramic particles, which is generated by the bonding to the partition walls of the honeycomb structure. In addition to the cordierite particles and/or the amorphous silica particles, mullite ceramic, etc. may be added. The ceramic particles have the maximum particle size of preferably 200 μm or less, more preferably 100 μm or less, and an average diameter of preferably 5-50 μm , more preferably 5-15 μm .

[0028] The ceramic particles constituting the plugs are preferably composed of pulverized powder of the same material as the sintered ceramic honeycomb body, because a small difference in a thermal expansion coefficient between the plugs and the sintered cordierite ceramic honeycomb body prevents cracking from occurring in the plugs or interfaces between the plugs and the honeycomb structure, and the plugs from peeling. In this case, the ceramic particles need not necessarily be composed only of pulverized powder of the same material as the sintered ceramic honeycomb body, but may be cordierite particles, or their mixtures with amorphous silica particles, mullite ceramic particles, etc.

[0029] The colloidal oxide forming the amorphous oxide matrix of the plug comprises colloidal silica and/or colloidal alumina as a main component, because (a) the viscosity of the plugging material composed of colloidal silica and/or colloidal alumina can be properly adjusted, thereby making it possible

to surely filling the plugging material into flow paths even in their corners, to provide a high bonding strength between the partition walls and the plugs, and because (b) the colloidal silica and/or colloidal alumina are well bonded to the ceramic particles, thereby forming high-strength plugs.

5 [0030] The colloidal oxide is preferably 1-50 parts by mass per 100 parts by mass of the ceramic particles on a solid basis. When the colloidal oxide is less than 1 part by mass on a solid basis, the amorphous oxide matrix formed by the colloidal oxide does not have a sufficient bonding force to the ceramic particles, resulting in the likelihood that the plugs peel off. On the other hand,
10 when the colloidal oxide exceeds 50 parts by mass on a solid basis, the plugs have too large a thermal expansion coefficient, resulting in the likelihood that the ceramic honeycomb filter, to which the plugs are bonded, have a low thermal shock resistance. The amount of the colloidal oxide added is more preferably 2-35 parts by mass, most preferably 5-20 parts by mass, per 100
15 parts by mass of the ceramic particles on a solid basis.

[0031] The plugging material for the ceramic honeycomb filter of the present invention may contain ceramic fibers, cement, etc. if necessary, in addition to the ceramic particles and the colloidal oxide. Also, to adjust the viscosity of the plugging material, thereby improving workability, an organic
20 binder such as methylcellulose, etc., a dispersant, etc. may be added.

[0032] [2] ceramic honeycomb filter

[0033] Fig. 1 is a perspective view showing one example of the appearance of the ceramic honeycomb filter, to which the present invention is applicable, and Fig. 2 is a cross-sectional view of the ceramic honeycomb filter of Fig. 1
25 used as an exhaust-gas-cleaning filter. As shown in Figs. 1 and 2, the ceramic honeycomb filter 1, to which the present invention is applicable, is constituted by a sintered ceramic honeycomb body 11 comprising a peripheral wall 11a and porous partition walls 11b inside the peripheral wall 11a, and

plugs 12a, 12b alternately sealing open ends of the flow paths 11c encircled by the porous partition walls 11b. The ceramic honeycomb filter 1 is received in a metal container 14 with the peripheral wall 11a fixed by holding members 13a, 13b.

5 [0034] The percentage of the amorphous oxide matrix in the plugs 12a, 12b is substantially the same as that of the colloidal oxide in the plugging material. Namely, the amorphous oxide matrix is preferably 1-50 parts by mass, more preferably 2-35 parts by mass, most preferably 5-20 parts by mass, per 100 parts by mass of the ceramic particles.

10 [0035] The exhaust gas 10a containing particulate matter flows into the flow paths 11c through inlet-side open ends, pass through the porous partition walls 11b, and are discharged as a cleaned gas 10b from the exit-side open ends via the adjacent flow paths 11c. While passing through the porous partition walls 11b, the particulate matter contained in the exhaust gas 10a is captured in fine
15 pores in the porous partition walls 11b. Thus, the ceramic honeycomb filter 1 acts as an exhaust-gas-cleaning filter.

[0036] The ceramic honeycomb filter of the present invention can be used not only for an alternate regeneration method, but also for a continuous regeneration method for continuously burning particulate matter in
20 combination with a precious metal catalyst.

[0037] [3] Production method of ceramic honeycomb filter

[0038] The production method of the ceramic honeycomb filter of the present invention is characterized in charging a plugging material containing ceramic particles and colloidal oxide into predetermined flow paths of the
25 sintered ceramic honeycomb body made of a cordierite-based ceramic material, and heating it at a temperature of 1000°C or lower.

[0039] In the present invention, the inclusion of the colloidal oxide makes the bonding temperature of the plugging material as low as 1000°C or lower,

making it unnecessary to conduct sintering at as high a cordierite-forming temperature as 1300°C or higher as conventional plugging materials.

Accordingly, residual stress generated by the bonding of the plugs to the sintered ceramic honeycomb body can be reduced. By suppressing the residual stress, it is possible to avoid such problems as thermal shock by an exhaust gas and mechanical shock by engine vibration and vibration by contact with roads when mounted to automobiles, cracking in the plugs or in interfaces between the plugs and the honeycomb structure, the peeling of the plugs, etc. Also, because the bonding temperature is as low as 1000°C or lower, a heating energy cost can be reduced.

[0040] When the colloidal oxide in the plugging material is dewatered at a temperature of 1000°C or lower, a strong, solid, amorphous oxide matrix can be formed irreversibly, thereby strongly adhering the ceramic particles, and strongly bonding the plugging material to the partition walls of the sintered ceramic honeycomb body. Because the plugs contain the ceramic particles and the amorphous oxide matrix formed from the colloidal oxide, the plugs have a small thermal expansion coefficient, so that only a small difference in a thermal expansion coefficient exists between the plugs and the sintered cordierite ceramic honeycomb body having a low thermal expansion coefficient. Accordingly, the ceramic honeycomb filter of the present invention has small residual stress.

[0041] Why the temperature of bonding the plugs to the partition walls is as low as 1000°C or lower is that an aqueous colloidal oxide in the plugging material is fully dewatered at 1000°C or lower to irreversibly provide a strong solid, namely, an amorphous oxide matrix. Accordingly, the ceramic particles are not only strongly adhered to each other but also strongly bonded to the partition walls of the sintered ceramic honeycomb body at a temperature of 1000°C or lower, so that the plugs are integrally fixed to the partition walls.

The temperature for bonding the plugging material to the partition walls need only be a temperature of dewatering the colloidal oxide or higher, and its upper limit may generally be 1000°C, particularly 500°C, further 150°C.

Particularly when the plug-bonding temperature is 500°C or lower, residual stress generated by the difference in a thermal expansion coefficient between the honeycomb structure and the plugs can be made smaller, thereby reducing an energy cost for bonding. The lower limit of the plug-bonding temperature is preferably 50°C.

[0042] Using a plugging material for the ceramic honeycomb filter of the present invention, the ceramic honeycomb filter comprising two sintered ceramic honeycomb bodies integrally bonded to each other via plugs in a flow path direction can be obtained by charging the plugging material into open ends of the predetermined flow paths of both sintered ceramic honeycomb bodies, abutting both plugging materials of the sintered ceramic honeycomb bodies, and heating them at a temperature of 1000°C or lower. In this case, with plugs formed only in the downstream-side open ends of the upstream-side, sintered ceramic honeycomb body, a ceramic honeycomb filter having space upstream of the inlet-side plugs can be obtained. The ceramic honeycomb filter having such structure can effectively capture particulate matter in the exhaust gas in the space upstream of the inlet-side plugs. The filter can be regenerated by burning the captured particulate matter by an external ignition means disposed on the inlet side. In this case, too, because the plugs and the partition walls of both sintered ceramic honeycomb bodies are strongly and integrally bonded to each other, the ceramic honeycomb filter can withstand thermal shock due to rapid temperature variations.

[0043] The present invention will be described in detail referring to Examples below without intention of limiting the present invention thereto.

[0044] Examples 1-27, Comparative Examples 1-3, Conventional Example 1

(1) Production of sintered ceramic honeycomb body

[0045] Cordierite-forming materials were blended and extrusion-molded to form a green body having a honeycomb structure. This green body was sintered at a temperature of 1425°C to obtain a sintered cordierite ceramic honeycomb body having an outer diameter of 266.7 mm and a length of 304.8 mm.

[0046] (2) Preparation of plugging material slurry

The ceramic particles and the colloidal oxide shown in Table 1 were mixed at ratios shown in the rows of Examples 1-27 in Table 2, and 1.2 parts by mass of methylcellulose as an organic binder and water were added to 100 parts by mass of the ceramic particles to form a plugging material slurry of Examples 1-27 capable of sealing the sintered ceramic honeycomb body. Used as the ceramic particles were fused silica A in Examples 1-9, fused silica B in Examples 10-12, and cordierite powder (powder obtained by pulverizing a cordierite honeycomb structure having a porosity of 65%) in Examples 13-27. Also used as the colloidal oxide were colloidal silica in Examples 1-25, and colloidal alumina in Examples 26 and 27.

[0047] Each plugging material of Comparative Examples 1-3 shown in Table 3 was blended with 1.2 parts by mass of methylcellulose as an organic binder and water, to obtain a plugging material slurry of Comparative Examples 1-3 capable of sealing the sintered ceramic honeycomb body. In Comparative Examples 1 and 2, cordierite powder (powder obtained by pulverizing a cordierite honeycomb structure having a porosity of 65%) shown in Table 1, and unsintered cordierite-forming material powder comprising 15% of talc, 24% of calcined talc, 20% of kaolin, 26.5% of calcined kaolin and 14.5% of alumina on a mass basis were used. In Comparative Example 3, only unsintered cordierite-forming material powder was used.

[0048] 1 part by mass of methylcellulose, 9.25 parts by mass of glycerin, and

30 parts by mass of water were added to 100 parts by mass of unsintered cordierite-forming material powder, which was the material batch No. 1 described in Example of JP63-28875B (38.2% of calcined talc, 20.0% of kaolin, 21.8% of calcined kaolin, 10.5% of alumina, and 9.5% of aluminum hydroxide, on a mass basis) and blended, to form a plugging material slurry of Conventional Example 1 capable of sealing the sintered ceramic honeycomb body.

[0049] (3) Plugging method

[0050] As shown in Fig. 3, a resin mask 21 having openings for plugging predetermined flow paths of the sintered ceramic honeycomb body was provided. To provide the mask 21 with openings, machining, heating, punching, etc. are used.

[0051] As shown in Fig. 3(a), with predetermined openings of the flow paths 11c on one side sealed by the resin mask 21, the honeycomb structure 11 was immersed in each plugging material slurry 12c in a container 20. Water was absorbed in the partition walls from the slurry that entered into the flow paths through the open ends of the honeycomb structure 11, so that plugs were formed. As shown in Fig. 3(b), the honeycomb structure 11 was lifted out of the plugging material slurry 12c, and the plugs 12a was dried. The same immersion treatment was conducted to the openings of the sintered ceramic honeycomb body 11 on the other side, to obtain a honeycomb structure whose flow paths were alternately sealed.

[0052] To bond the plugs to the partition walls 11b of the sintered ceramic honeycomb body 11 strongly, the plugs of each honeycomb structure was heated at a temperature shown in Tables 2 and 3. Taking into consideration influence on thermal shock resistance, any plug of the resultant ceramic honeycomb filter was set to 10 mm.

[0053] (4) Evaluation

[0054] Each of the resultant ceramic honeycomb filters was evaluated with respect to thermal shock resistance and the strength of the plugs.

[0055] (a) Thermal shock resistance

[0056] Each ceramic honeycomb filter was heated from room temperature to a predetermined temperature in an electric furnace, kept at the predetermined temperature for 2 hours, and taken out of the electric furnace, to observe cracking. The evaluation standards of the thermal shock resistance are as follows:

Excellent: Not cracked at 600°C or higher.

Good: Not cracked at 550°C or higher and lower than 600°C.

Fair: Not cracked at 500°C or higher and lower than 550°C.

Poor: Cracked at lower than 500°C.

[0057] When no cracking occurred at 500°C or higher (from “Excellent” to “Fair”), the ceramic honeycomb filter passed the thermal shock resistance test, and when cracking occurred at lower than 500°C, it failed. The thermal shock resistance evaluation results are shown in Tables 2 and 3.

[0058] (b) Strength of plugs

[0059] Each plug was pressed by a spherical tip end (diameter: 1.0 mm) of an indenter to measure its fracture strength. With the plug strength of

Conventional Example 1 being 1.0, the strength of each plug is shown by a relative value in Tables 2 and 3.

[0060]

Table 1

Type	Composition	Average Diameter (μm)	Solid Component (% by mass)
Ceramic Particles	Fused Silica A	14.1	-
	Fused Silica B	30.1	-
	Cordierite (Porosity: 65%)	12.0	-
Colloidal Oxide	Colloidal Silica	-	50
	Colloidal Alumina	-	30

[0061]

Table 1 (continued)

Type	Composition	Composition (% by mass)							
		SiO ₂	Al ₂ O ₃	MgO	Na ₂ O	K ₂ O	CaO	Fe ₂ O ₃	TiO ₂
Ceramic Particles	Fused Silica A	99.9	0.08	-	0.003	0.002	-	0.001	-
	Fused Silica B	99.6	0.1	-	0.004	0.002	0.02	0.02	-
	Cordierite (Porosity 65%)	50.5	33.7	14.9	0.17	0.001	0.09	0.49	0.09
Colloidal Oxide	Colloidal Silica	99.3	≤0.1	≤0.1	0.5	-	≤0.1	-	-
	Colloidal Alumina	≤0.1	99.5	≤0.1	0.3	-	≤0.1	-	-

[0062] Table 2

No.	Composition of Plugging Material ⁽¹⁾			
	Ceramic Particles		Colloidal Oxide	
	Type	Parts by Mass	Type	Parts by Mass
Example 1	Fused Silica A	100	Colloidal Silica	12.5
Example 2	Fused Silica A	100	Colloidal Silica	12.5
Example 3	Fused Silica A	100	Colloidal Silica	12.5
Example 4	Fused Silica A	100	Colloidal Silica	40.0
Example 5	Fused Silica A	100	Colloidal Silica	35.0
Example 6	Fused Silica A	100	Colloidal Silica	20.0
Example 7	Fused Silica A	100	Colloidal Silica	5.0
Example 8	Fused Silica A	100	Colloidal Silica	2.0
Example 9	Fused Silica A	100	Colloidal Silica	1.0
Example 10	Fused Silica B	100	Colloidal Silica	12.5
Example 11	Fused Silica B	100	Colloidal Silica	20.0
Example 12	Fused Silica B	100	Colloidal Silica	20.0
Example 13	Cordierite	100	Colloidal Silica	12.5
Example 14	Cordierite	100	Colloidal Silica	40.0
Example 15	Cordierite	100	Colloidal Silica	35.0
Example 16	Cordierite	100	Colloidal Silica	20.0
Example 17	Cordierite	100	Colloidal Silica	5.0
Example 18	Cordierite	100	Colloidal Silica	12.5
Example 19	Cordierite	100	Colloidal Silica	5.0
Example 20	Cordierite	100	Colloidal Silica	2.0
Example 21	Cordierite	100	Colloidal Silica	35.0
Example 22	Cordierite	100	Colloidal Silica	20.0
Example 23	Cordierite	100	Colloidal Silica	5.0
Example 24	Cordierite	100	Colloidal Silica	2.0
Example 25	Cordierite	100	Colloidal Silica	1.0
Example 26	Cordierite	100	Colloidal Alumina	12.5
Example 27	Cordierite	100	Colloidal Alumina	12.5

Note: (1) The amount of the colloidal silica and the colloidal alumina are expressed on a solid basis.

[0063]

Table 2 (continued)

No.	Bonding Temperature of Plugs (°C)	Thermal Shock Resistance	Relative Strength of Plugs
Example 1	1000	Fair	1.5
Example 2	850	Fair	1.5
Example 3	500	Fair	1.6
Example 4	500	Fair	2.0
Example 5	150	Fair	1.9
Example 6	150	Good	1.9
Example 7	150	Good	1.9
Example 8	500	Good	1.7
Example 9	500	Good	1.5
Example 10	850	Fair	1.5
Example 11	500	Fair	1.5
Example 12	150	Fair	1.9
Example 13	1000	Fair	1.6
Example 14	850	Fair	1.9
Example 15	850	Fair	1.8
Example 16	850	Good	1.7
Example 17	850	Good	1.7
Example 18	500	Excellent	1.9
Example 19	500	Excellent	1.9
Example 20	500	Good	1.7
Example 21	150	Good	1.9
Example 22	150	Excellent	1.9
Example 23	150	Excellent	1.9
Example 24	150	Good	1.7
Example 25	150	Good	1.5
Example 26	850	Good	1.5
Example 27	150	Good	1.4

[0064]

Table 3

No.	Composition of Plugging Material			
	Ceramic Particles		Colloidal Oxide	
	Type	Parts by Mass	Type	Parts by Mass
Comparative Example 1	Cordierite	100	Unsintered Cordierite Powder	50
Comparative Example 2	Cordierite	100	Unsintered Cordierite Powder	50
Comparative Example 3	-	-	Unsintered Cordierite Powder	100
Conventional Example 1	-	-	Unsintered Cordierite Powder	100

[0065]

Table 3 (Continued)

No.	Bonding Temperature of Plugs (°C)	Thermal Shock Resistance	Relative Strength of Plugs
Comparative Example 1	1000	Poor	0.2
Comparative Example 2	1400	Poor	0.9
Comparative Example 3	1000	Poor	0.2
Conventional Example 1	1400	Poor	1

- 5 [0066] It is clear from Tables 2 and 3 that the ceramic honeycomb filters of Examples 1-27 are much superior to those of Comparative Examples 1-3 and Conventional Example 1 in thermal shock resistance and the strength of plugs. In Comparative Example 2 and Conventional Example 1, in which plugs were bonded at 1400°C, cracking occurred in the ceramic honeycomb filter at lower
- 10 than 500°C. On the other hand, in Examples 1 and 13, in which the plug-bonding temperature was 1000°C, the ceramic honeycomb filters was evaluated as "passed," because their thermal-shock-resisting temperatures were 500°C or higher. Also, in Examples 2-12 and 14-27, in which the plug-bonding temperature was 150°C-850°C, the thermal-shock-resisting
- 15 temperatures were 500°C or higher. Particularly in Examples 18, 19, 22 and

23, in which the plug-bonding temperature was 500°C or lower, powder obtained by pulverizing a honeycomb filter sintered bodies was used as the ceramic particles, and colloidal silica was used as the colloidal oxide in an amount of 5-20 parts by mass on a solid basis, the thermal-shock-resisting temperatures of the ceramic honeycomb filters were as extremely high as 600°C, exhibiting excellent thermal shock resistance.

EFFECT OF THE INVENTION

[0067] The sintered ceramic honeycomb filter of the present invention is advantageous in that (a) because the plugs contain ceramic particles, there is a small difference in a thermal expansion coefficient between the plugs and the sintered ceramic honeycomb body, and that (b) because the plugs comprise an amorphous oxide matrix formed by a colloidal oxide, the plugging material is bonded to the sintered ceramic honeycomb body at low temperatures, resulting in a small residual stress. Accordingly, the ceramic honeycomb filter of the present invention has excellent thermal shock resistance with much reduced production cost.